

Work Order ID 60030

June 23, 2010 8:30:12 AM



Page 1

Item ID: D3191-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Backer Plate

Start Date: 6/23/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 10/6/23 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3191	Rev B
-------	-------

0.00

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3191 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

6061 .063

B 10-6-23

(S)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 10-6-23

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S 10/06/23

(XJ)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60030

June 23, 2010 8:30:12 AM



Page 2

Item ID: D3191-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Backer Plate

Start Date: 6/23/10

Start Qty: 4.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MM 10 06 24 (5)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-6-24 (5)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:10

OVEN TEMPERATURE:

3200 FINISH TIME:

1140

5 BR 10-6-28

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60030

June 23, 2010 8:30:12 AM



Page 3

Item ID: D3191-1

Accept



Setup Start



Revision ID:

Item Name: Backer Plate

Stop



Start Date: 6/23/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 06 28 (5)

170

Identify as per dwg & Stock Location: ay

0.00



Packaging

Memo

0.00

Packaging

10/6/29 (5)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29 MF
10-6-29

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 23, 2010 8:30:12 AM

Page 1

Work Order ID: 60030



Parent Item: D3191-1



Parent Item Name: Backer Plate

Start Date: 6/23/10

Required Date: 6/25/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-08-01 new issue DD verified by:EC
IPP Rev:B 09-01-28 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

122.0000

0.125

0.526316

.55



B 10-6-23

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT21

122

113608

122

113609

5

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CL 10/6123
W10: 60030

RELEASE
09/09/15

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3191-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -1: 0.10 lbs
-3: 0.10 lbs
-5: 0.09 lbs

B	TRANSFERRED TO "B" SIZE DRAWING AND UPDATED TO CURRENT STANDARDS. ADDED -5. REASON: SEE NCR 08-110.		AJS	08.11.26
A	NEW ISSUE		CP	03.05.27
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3191	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BACKER PLATE	NTS	
DATE	08.11.26		<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

